

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014556**Date Inspected:** 27-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 0**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Layout for fit up of DP 3134-001 by ZPMC personnel. Tack Welding of DP 3078-001. The welder was identified as 059440 and 059366. The WPS was identified as WPS-B-T-2342-U5B(U-Rib). Preheat for the operation was proven to be in excess of 66C by the use of a temp stick. The ZPMC QC was identified as Zhu Zhong Jie.

Welding of FB 3107-001-015, 16, 17, 18. The Welding Procedure was identified as WPS-B-T-2132-3. The welder was identified as 208035. The ZPMC QC was identified as Zhu Lin. The ZPMC CWI was identified as Li Zhi Jiang.

Welding of FB 3147-001-029. The Welding Procedure was identified as WPS-B-T-2132-3. The welder was identified as 214945. The ZPMC QC was identified as Zhu Lin. The ZPMC CWI was identified as Li Zhi Jiang.

Welding of FB 3159-001-037,038. The Welding Procedure was identified as WPS-B-T-2232-Tc-U4b-F. The welder was identified as 050977. The ZPMC QC was identified as Zhu Lin. The ZPMC CWI was identified as Li Zhi Jiang.

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Welding of Traveler Rail 20TR2-045-015. The welder was identified as 219188. The WPS was identified as WPS-B-T-2233-Tc-U4b-F. The ZPMC QC was identified as Zhu Lin. The ZPMC CWI was identified as Li Zhi Jiang.

Heat straightening to traveler rails 21TR4-004 and 21TR3-001 pursuant to heat straightening report HSR(B)-363. The ZPMC QC was identified as Zhu Lin. The ZPMC CWI was identified as Li Zhi Jiang.

Welding of WD1-A28A/B-72, 68, 66, 61, 60, and 55. The welders were identified as 054069, 054069, 053116, 054069, 053116, and 053116 respectively. The ZPMC QC was identified as Yuan Hin Gang. The ZPMC CWI was identified as Li Lin.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
